

Date: Wednesday, 09/07/2008 2:08:21 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SS WEARSHOE KITS
Job Number : 40407	
Estimate Number : 12802	
P.O. Number :	Part Number : DSI9367011
This Issue : 09/07/2008 S.O. No. :	Drawing Number : DSI9367 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 35430	Material :
Written By :	Due Date : 10/07/2008 Qty: 2 Um: Each
Checked & Approved By : <u>MF 08-07-09</u>	
Comment : Est Rev:A New Issue 07-03-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPDSI9367-011 CHG 001

S006710

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D35641	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

WEARSHOE

Batch: 39286

4.0	D35661	Gasket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

GASKET

Batch: 40092

5.0	D35643	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

WEARSHOE

Batch: 34052

PU 8/2/10 (2)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35645

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

WEARSHOE

Batch: 39573

7.0

D35665

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

GASKET

Batch: 39998

8.0

AN3C4A

BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total: 48.0000 Each(s)

BOLT

Batch: B M108568 New Batch

9.0

AN3C6A

BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

BOLT

Batch: M105300

10.0

AN3C7A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)

BOLT

Batch: M105906

11.0

AN960C10L

washer



Comment: Qty.: 44.0000 Each(s)/Unit Total: 88.0000 Each(s)

washer

Batch: M108246

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

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Drawing Name: SS WEARSHOE KITS

Job Number: 40407

Part Number: DSI9367011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Dsi9367-011

Location: _____

PPP Rev: _____

Rev A

JS 08/07/10

(x2)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/15

MF 08-07-14

Job Completion



DART

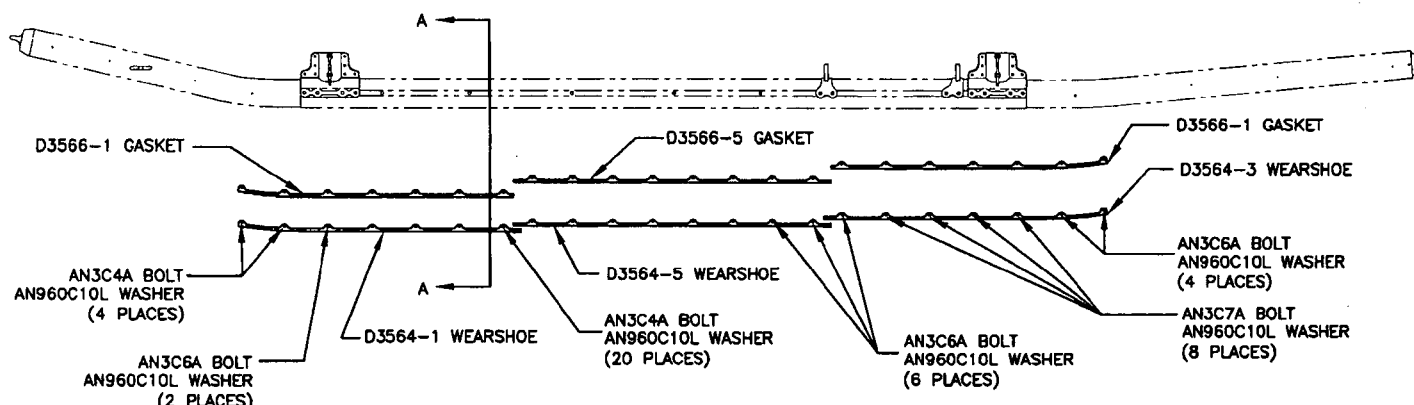
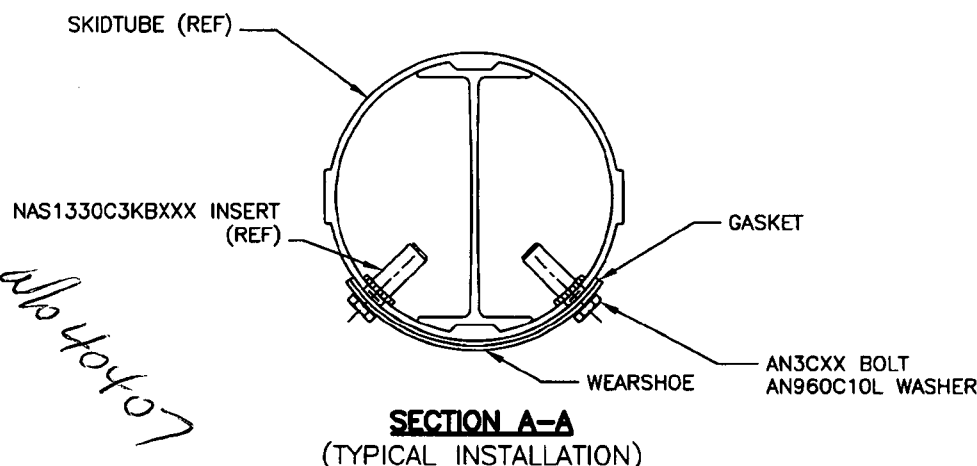


FIGURE 1: DSI 9367-011 WEARSHOE KIT



SECTION A-A
(TYPICAL INSTALLATION)

DSI 9367-011 Wearshoe Kit Installation Procedure

- 1) Remove skidtube from aircraft per Section 32.1 of ICA-D412-742.
- 2) Remove existing D3460-1/-3 and D2577-5 wearshoes by removing AN3C hardware. Begin wearshoe removal from the fwd end of the skidtube towards the aft end.
Note: Removing the wearshoes will require breaking a layer of sealant between the wearplates and the skidtube.
- 3) Clean residual sealant off the bottom of the skidtube. Check for corrosion and mechanical damage in accordance with Chapter 5 of ICA-D412-742 and repair as required.
- 4) Install D3564-1/-3/-5 wearshoes complete with D3566-1/-5 gaskets using AN3C bolts beginning from the aft end of the skidtube and install towards the fwd end of the skidtube as shown in Figure 1. Seal all bolts with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant before installing. Torque bolts to 15-25 in-lbs (1.7-2.8 N-m).
- 5) Re-install skidtube on aircraft per Section 32.2 of ICA-D412-742.

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	07.02.09	TITLE	DSI 9367	REV. A
				SHEET 2 OF 3
				SCALE
				NTS

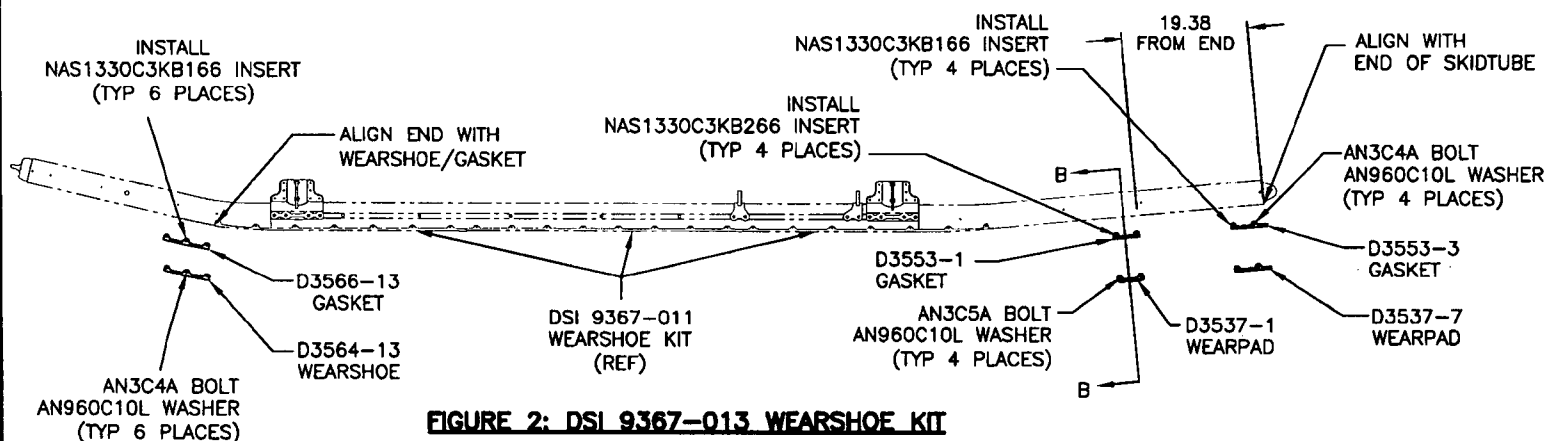
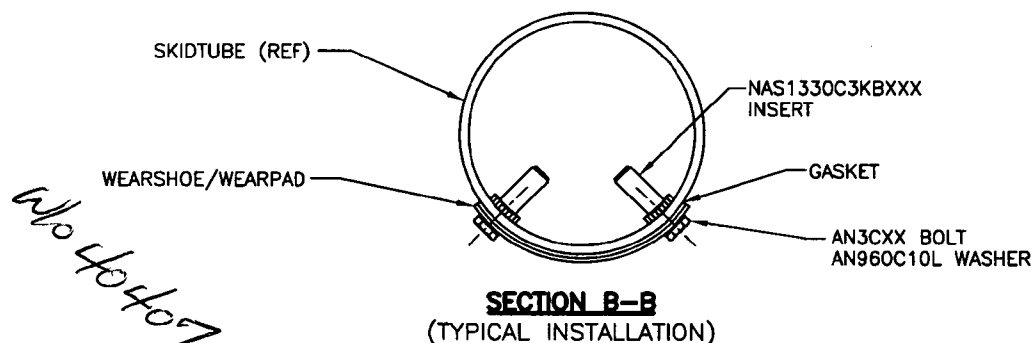


FIGURE 2: DSI 9367-013 WEARSHOE KIT



SECTION B-B
(TYPICAL INSTALLATION)

DSI 9367-013 Wearshoe Kit Installation Procedure

- 1) Remove skidtube from aircraft per Section 32.1 of ICA-D412-742.
- 2) Check skidtube for corrosion and mechanical damage in accordance with Chapter 5 of ICA-D412-742 and repair as required.
- 3) Locate the wearshoe/wearpads and gaskets as shown in Figure 2.
- 4) Using the wearshoe/wearpad/gasket as a template, drill $\varnothing 0.125$ " holes in the center of the wearshoe/wearpad obrounds. Remove the wearshoe/wearpad/gasket and drill qty (14) $\varnothing 0.250$ " - $\varnothing 0.257$ " holes for installing the required inserts, countersink all holes to $\varnothing 0.391 \times 100^\circ$. Deburr and remove swarf from inside of skidtube.
- 5) Touch up holes with chemical film material (Alodine 1200/1201) per MIL-C-5541 and one coat of MIL-P-85582 or MIL-P-23377 primer. Install NAS1330C3KB inserts using Sikaflex -241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant prior to installation.
- 6) Install D3564-13 wearshoes and D3537-1/-7 wearpads complete with D3566-13 and D3553-1/-3 gaskets using AN3C bolts as applicable. All bolts should be sealed with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant before installing. Torque bolts 15-25 in-lbs (1.7-2.8 N-m).
- 7) Re-install skidtube on aircraft per Section 32.2 of ICA-D412-742.

DART

DESIGN	BY	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	BY	APPROVED	PORT HADLOCK, WA
DATE	07.02.09	DRAWING NO.	DSI 9367
		TITLE	STAINLESS STEEL WEARSHOE KITS
		SCALE	NTS
		REV. A	SHEET 3 OF 3